

46502

DART AEROSPACE LTD	Work Order:	21770
Description: Outer Aft Saddle	Part Number:	D5955
Drawing: D5955 Rev. A	Qty:	6

RT
02.05.16

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order Dwg. not required	RT	04.10.22	6
2	STORES	Issue material from stock: D6101-013 (7075-T7351) Cut Size 2.50" x 10.10" X 8.25" (Grain along 10.10") Batch: B21800	RT	05/05/05	6
3	HAAS	Setup W/O No. NA Setup Inspection last completed 05/05/05 by T36	T36	05/05/05	6
4	HAAS	Machine as per folio D5955 Ensure Batch Number is entered	T36	05/05/05	6
5	HAAS	Deburr and Tumble	T36	05/05/06	6
6	QC	Inspect Level 1 Fill Out Inspection Sheet	RT	05/05/06	6
7	QC	Inspect Level 8 Audit Inspection Sheet	En	05/05/06	6
8	METAL	Acid etch and alodine as per QSI 005 4.1	ML	05/05/06	6
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	ML	05/05/06	6
10	QC	Inspect Level 3	CL	05/05/17	6
11	STORES	Pack in foam, identify and stock	CL	05/05/17	6
12	EXPEDITING	Close Work Order Cost / Part 197.10 SUC 05/05/18 (6)	RT	05.05.24	6

Rev	Date	Change	Revised By	Approved
A	97.03.05			
B	99.04.19	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED

02/02/06



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	21770
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955 Rev. A		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D5955 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.749	1.750	1.750	1.749		
C	5.245	5.255		5.248	5.250	5.249	5.249		
D	6.995	7.005		7.002	7.001	7.002	7.002		
E	5.745	5.755		5.749	5.749	5.750	5.750		
F	4.745	4.755		4.749	4.750	4.749	4.750		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.527	1.527	1.527	1.528		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.581	4.580		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		.250	.250	.250	.250		
M	0.490	0.510		.506	.506	.503	.504		
N	0.240	0.260		.248	.250	.250	.250		
O	7.990	8.010		8.006	8.006	8.005	8.006		
P	0.240	0.260		.250	.250	.250	.250		
Q	0.307	0.312		.312	.712	.311	.312		
R	0.760	0.765		.761	.761	.761	.761		
S	0.490	0.510		.501	.501	.502	.502		
T	1.625	1.645		1.626	1.630	1.631	1.628		
U	2.000	2.020		2.001	2.002	2.005	2.003		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	BC.
Date:	05/05/05

Audited by:	CP
Date:	05/05/06

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	

RELEASED
03.06.18

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B	1.745	1.755		1.750	1.749				
C	5.245	5.255		5.250	5.251				
D	6.995	7.005		7.001	7.002				
E	5.745	5.755		5.750	5.750				
F	4.745	4.755		4.750	4.750				
G	0.313	0.318	DT8686	✓	✓				
H	1.522	1.532		1.528	1.526				
I	3.048	3.058		3.053	3.054				
J	4.575	4.585		4.580	4.580				
K	0.313	0.318	DT8686	✓	✓				
L	0.240	0.260		.250	.250				
M	0.490	0.510		.501	.502				
N	0.240	0.260		.250	.250				
O	7.990	8.010		8.006	8.007				
P	0.240	0.260		.250	.250				
Q	0.307	0.312		.312	.312				
R	0.760	0.765		.761	.761				
S	0.490	0.510		.502	.503				
T	1.625	1.645		1.630	1.632				
U	2.000	2.020		2.005	2.007				
V									
W									
X									
Y									
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Measured by:	BC
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RELEASED
03.06.18

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 21, 2004
08:51 am

Work Order No : 0021770
Project Name : D5955
Project For : WK446
Work Order Type : Main
Main WO Number :
House Part Number : D5955

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Description : Saddle
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 10-20-04
Est Finish Date : 11-11-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00